

**Work Order ID 165909**

Tuesday, September 05, 2017 1:06:21 PM

**\*165909\***

Page 1

Item ID: D3913-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Hinge Rib  
Start Date: 9/6/2017 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 9/7/2017 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan:                      Date: SEP 05 2017 Tooling:                      Date:                      Run Start **\*NR1\***  
QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3913    | D            |

100 0.00

**\*100\***

Large Fab

**Memo**

0.72

Large Fab

- 1- Cut tube as per dwg D3913
- 2- remove identification marks and deburr

4x D.M.L 2017-9-5

110

QC6- All purchased or subcontracted products 0.00

**\*110\***

QC

**Memo**

0.00

Quality Control

4 SEP 06 2017DAS  
24  
9-89

120

Identify as per dwg & Stock Location: WA04 0.00**\*120\***

Packaging

**Memo**

0.04

Packaging

LOCATION: WA004

4 SEP 06 2017DAS  
24  
9-89

**Work Order ID 165909****\*165909\***

Page 2

Tuesday, September 05, 2017 1:06:21 PM

Item ID: D3913-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Hinge Rib  
Start Date: 9/6/2017 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 9/7/2017 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.40                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

Wm

SEP 07 2017

DAS  
21  
9-89

# Picklist Print

Tuesday, September 05, 2017 1:06:21 PM

Page 1

Work Order ID: 165909

\*165909\*

Parent Item: D3913-9

\*D3913-9\*

Parent Item Name: Hinge Rib

Start Date: 9/6/2017

Required Date: 9/7/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.049                |                        | Purchased     |             |                     | No               | 100             | f                  | 394.4895       | 7.875       | 33.15789     |               |                |        |
| *M304TS0 750W 049*              |                        |               |             |                     |                  |                 |                    |                | **          |              |               |                |        |
| 304 SQ Tube .75x.75x.049W       |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

D.M.L 2017-9-5

## Location

WA004

## Loc Qty

394.489474

## Loc Code

M137401

0.689474

M137625

70.3

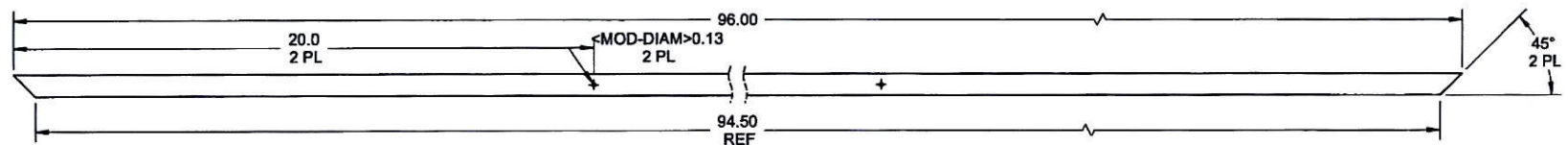
M137934

23.5

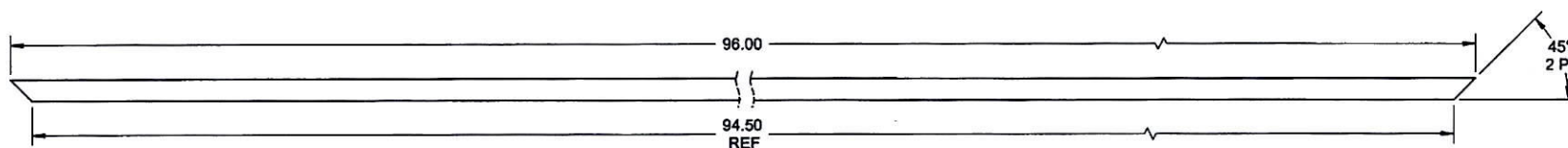
M138160

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137934 9  
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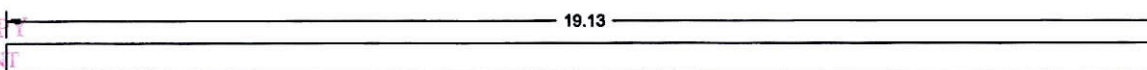


**D3913-1 RIB**

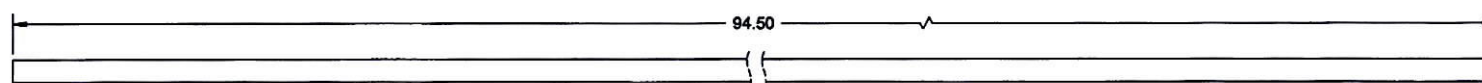
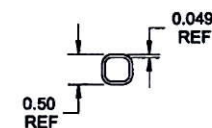


**D3913-3 RIB**

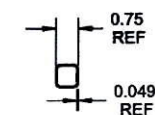
SHOP COPY  
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WORK ORDER  
SEP 05 2017



**D3913-7 RIB**



**D3913-9 HINGE RIB**



**NOTES:**

- 1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED  
2017-06-07

APPROVED

|            |          |                                                                                                                                                                                                                                                                                          |              |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |              |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                                                          |              |
| CHECKED    | JMH      | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. D       |
| MFG. APPR. | DD       | <b>D3913</b>                                                                                                                                                                                                                                                                             | SHEET 6 OF 6 |
| APPROVED   | WM       | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   | DSC      | <b>LONG BASKET BASE ASSY (350)</b>                                                                                                                                                                                                                                                       | NTS          |
| DATE       | 16.11.21 | <small>COPYRIGHT © 2018 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

Monday, July 03, 2017 2:47:17 PM

All amounts are calculated in domestic currency.

All Item ID/GL/WOs    All Rec. Employees    All Currencies

### Grouped by Vendor ID

| Purchase Order ID/<br>Curr Type | Line Nbr/<br>Insp Req | Project ID | Reference/<br>Description/<br>Cert Std         | PO U/M /<br>Stock U/M | Required Date<br>Required Qty | Recv Date/<br>Recv Emp | Recv Qty<br>(PO U/M) | Cost Per Unit/<br>Recv Value | Inspected Qty/<br>Rejected Qty<br>(PO U/M) | MRB Reject<br>Qty | Book Amt |
|---------------------------------|-----------------------|------------|------------------------------------------------|-----------------------|-------------------------------|------------------------|----------------------|------------------------------|--------------------------------------------|-------------------|----------|
| VendorID\Vendor Name            |                       | VC-MET002  | Metaux Solutions                               |                       |                               |                        |                      |                              |                                            |                   |          |
| PO36689                         | 2                     |            | M304TS0.75x.049 f                              |                       | 6/29/2017                     | 7/3/2017               | 300.0000 ✓           | \$2.93                       | 0.0000                                     | 0                 | \$878.48 |
| CAD                             | No                    |            | 304 SQ Tube<br>.75x.75x.049W<br><u>m137934</u> |                       | 300.0000                      | PLOU01                 |                      | \$878.48                     | 0.0000                                     | 0                 |          |
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO36689

Purchase Order Date 6/14/2017

PO Print Date 6/14/2017

Page Number 1 of 2

Order From :  
METAUX SOLUTIONS  
2625 BOUL JACQUES-CARTIER EST  
LONGUEUIL, QC J4N 1L7  
CA

VC-MET002

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name  
Vendor Phone 800 558 8858  
  
Ship To Contact  
Ship To Phone  
Ship Via: Journey Freight collect  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

| Line Nbr                                                                                                                   | Reference Vendor Part Number<br>Line Comments<br>Delivery Comments | Description/<br>Mfg ID      | Req Date/<br>Taxable<br>Promise Date | CD | Req Qty/<br>Unit of<br>Measure | PO Unit Price | Extended Price |
|----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------|-----------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1                                                                                                                          | M304B0.250x0.500                                                   | 304 BAR .250 x .500         | 6/20/2017<br>Yes<br>6/20/2017        |    | 80.00<br>f 84.                 | \$4.25        | \$340.00       |
| MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS<br>AS PER ASTM A276 OR ASTM A240<br><br>NOTE: AISI 303 NOT ACCEPTABLE     |                                                                    |                             |                                      |    |                                |               |                |
| Line Total:                                                                                                                |                                                                    |                             |                                      |    |                                |               | \$340.00       |
| 2                                                                                                                          | M304TS0.750W.049                                                   | 304 SQ Tube<br>75x.75x.049W | 6/20/2017<br>Yes<br>6/20/2017        |    | 500.00<br>f                    | \$3.80        | \$1,900.00     |
| MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING<br>AS PER ASTM A554 MILL FINISH<br>OR<br>AS PER ASTM A269 MILL FINISH |                                                                    |                             |                                      |    |                                |               |                |
| Line Total:                                                                                                                |                                                                    |                             |                                      |    |                                |               | \$1,900.00     |

Note:

6/14/2017

## Shipping Order

29/06/2017

METAUX SOLUTIONS INC  
2625 BOUL JACQUES CARTIER EST  
LONGUEUÏL, QUEBEC  
J4N 1L7 Tel.: 450 641-3330

Order : 126407  
Reference : 36689  
Ship : PICK UP / PICK UP

Customer: 6323336

## Ship To

DART AEROSPACE LTD  
1270, ABERDEEN STREET  
HAWKESBURY, ONTARIO  
K6A 1K7

Same

Tel.: 1 613 632-3336

| Item No.            | Description                                                                            | Qty | Qty. Delivered | B/O Qty  |
|---------------------|----------------------------------------------------------------------------------------|-----|----------------|----------|
|                     | ***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR<br>LE PACKING SLIP INSCRIRE LES HEAT N |     |                |          |
| <u>SSQT34340494</u> | 304 SQ TUBE .750 X .049 WALL<br>15 x 20'<br><u>ake40273</u>                            | 300 | <u>300</u>     | <u>9</u> |

SHIP JOURNEY COLLECT

595



29-06-17

Shipping : \_\_\_\_\_  
Package No : \_\_\_\_\_  
Merchandise Received: \_\_\_\_\_

Ref. : \_\_\_\_\_  
\_\_\_\_\_

# Kingmaker Steel Co., Inc.

## Stainless Steel Tube and Pipe

133 Belmont Drive, Somerset, NJ 08873-1203  
Tel.: (732) 302-1800, Fax: (732) 302-1822

Date: 6/20/2017

Invoice No: KM2017/1426

Purchase P008120

Order No:

Sold To:

### Material Certification

ISO 9001:2015

ISO 14001:2004

EN 10204/3.1B

Ship To:

Stainless Steel T.L.G. Welded Tubing.

Country of Melt: Taiwan, Country of Origin: Taiwan.

| Item | Description             | Heat No.    | Finish | Specification | Grade  |
|------|-------------------------|-------------|--------|---------------|--------|
| 1:   | 3/4" SQ X 0.049"W X 20' | AKE040278As | MF     | ASTM A554-16  | MT-304 |
| 2:   |                         | 5           |        |               |        |
| 3:   |                         | 8-89        |        |               |        |
| 4:   |                         |             |        |               |        |
| 5:   |                         |             |        |               |        |

### CHEMICAL PROPERTIES

|    | C    | Si   | Mn   | P    | S    | Cr    | Ni   | Mo | N | Cu |
|----|------|------|------|------|------|-------|------|----|---|----|
| 1: | .040 | .510 | 1.08 | .029 | .014 | 18.10 | 8.14 |    |   |    |
| 2: |      |      |      |      |      |       |      |    |   |    |
| 3: |      |      |      |      |      |       |      |    |   |    |
| 4: |      |      |      |      |      |       |      |    |   |    |
| 5: |      |      |      |      |      |       |      |    |   |    |

### MECHANICAL PROPERTIES

|    | Tensile<br>(N/mm2) | Yield<br>(N/mm2) | Elong.<br>(%) | Hardness<br>(HRB) | Flattening | Hydrostatic | Eddy<br>Current |
|----|--------------------|------------------|---------------|-------------------|------------|-------------|-----------------|
| 1: | 673.00             | 235.00           | 46.00         | 82.80             |            |             |                 |
| 2: |                    |                  |               |                   |            |             |                 |
| 3: |                    |                  |               |                   |            |             |                 |
| 4: |                    |                  |               |                   |            |             |                 |
| 5: |                    |                  |               |                   |            |             |                 |

WE HEREBY CERTIFY THAT TO THE BEST OF OUR KNOWLEDGE, THE MATERIAL LISTED ABOVE HAS BEEN MANUFACTURED IN ACCORDANCE WITH AND MEET THE ABOVE APPLICABLE SPECIFICATIONS AND GRADES, AND ALSO THAT THE MATERIAL WAS PRODUCED IN A MERCURY FREE ENVIRONMENT. THE CHEMICAL COMPOSITIONS OF THE MATERIAL ARE IN ACCORDANCE WITH ASTM A240.

0002172



## MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304SS 0.750x0.49

PO / BATCH NO.: PO36689/M37934

DATE: JUL 06 2017

MATERIAL CERT REC'D: yes  
 QUANTITY RECEIVED: 300'  
 QUANTITY INSPECTED: 300'  
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049  
 THICKNESS RECEIVED: .051  
 SHEET SIZE ORDERED: N/A  
 SHEET SIZE RECEIVED: N/A

| DESCRIPTION                                        | NCR<br>(Check<br>Y/N)                | COMMENTS             |
|----------------------------------------------------|--------------------------------------|----------------------|
| SURFACE DAMAGE                                     | Y <input checked="" type="radio"/> N |                      |
| CORRECT FINISH                                     | <input checked="" type="radio"/> Y N |                      |
| CORROSION                                          | Y <input checked="" type="radio"/> N |                      |
| CORRECT GRAIN DIRECTION                            | <input checked="" type="radio"/> Y N |                      |
| CORRECT MATERIAL PER M-DRAWING                     | <input checked="" type="radio"/> Y N | <u>ASTM A554</u>     |
| CORRECT THICKNESS                                  | <input checked="" type="radio"/> Y N |                      |
| PHOTO REQUIRED                                     | Y <input checked="" type="radio"/> N |                      |
| CORRECT REF # TO LINK CERT                         | <input checked="" type="radio"/> Y N | <u>H# # AK040773</u> |
| CORRECT MATERIAL IDENTIFICATION                    | <input checked="" type="radio"/> Y N |                      |
| CORRECT M# ON THE MATERIAL                         | <input checked="" type="radio"/> Y N |                      |
| DOES THIS MATERIAL REQUIRE<br>ENGINEERING SIGN OFF | Y <input checked="" type="radio"/> N |                      |
| DOES THIS REQUIRE AN<br>EXTRUSION REPORT           | Y <input checked="" type="radio"/> N |                      |

| CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK.<br>RECORD RESULTS BELOW |     |     |       |       |
|------------------------------------------------------------------------------------|-----|-----|-------|-------|
| TYPE OF MATERIAL                                                                   | HRC | HRB | DUR A | DUR D |
| SIZE OF TEST SAMPLE                                                                |     |     |       |       |
| HARDNESS / DUROMETER READING                                                       |     |     |       |       |

testers located in the Quality Office

|                                                    |                                          |
|----------------------------------------------------|------------------------------------------|
| <b>QC 18 INSPECTION</b>                            | <b>ENGINEERING SIGNOFF (if required)</b> |
| INSPECTED BY: <u>5</u><br>DATE: <u>JUL 06 2017</u> | SIGNED OFF BY: _____<br>DATE: _____      |

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

PURCHASE MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING

FINISH: D  
 OR ASTM A554 MILL FINISH  
ASTM A289 MILL FINISH

WHERE: A.AAA = WIDTH IN INCHES  
 .TTT = WALL THICKNESS IN INCHES

PART NUMBER: M304TS | A.AAA | W | .TTT  
WIDTH WALL

PART NUMBER: EG. 0.75" X 0.75" X 0.049 WALL = M304TS0.750W.049

**RELEASED**  
 2014-05-26

|            |                                                                                                      |                                                          |                                                                                                                                                                                                                                                                                                                 |          |
|------------|------------------------------------------------------------------------------------------------------|----------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| D          | "SEAMLESS" REMOVED FROM PURCHASE MATERIAL SPECIFICATION (SEE NCR14-3818)                             |                                                          | DS                                                                                                                                                                                                                                                                                                              | 14.05.20 |
| C          | "SEAMLESS" ADDED TO PURCHASE MATERIAL. ASTM A289 ADDED TO FINISH. REASON: SPEC ADDED FOR 1/2" TUBING |                                                          | AJS                                                                                                                                                                                                                                                                                                             | 09.10.16 |
| B          | DRAWING MOVED TO "B" SIZE BORDER. FINISH ADDED (SEE NCR 08-045 FOR DETAILS).                         |                                                          | AJS                                                                                                                                                                                                                                                                                                             | 06.08.28 |
| A          | NEW ISSUE                                                                                            |                                                          | DS                                                                                                                                                                                                                                                                                                              | 01.06.08 |
| REV.       | DESCRIPTION                                                                                          |                                                          | BY                                                                                                                                                                                                                                                                                                              | DATE     |
| DESIGN     | DS                                                                                                   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                                                                                                                                                                                                                                                                                                                 |          |
| DRAWN      | DS                                                                                                   |                                                          |                                                                                                                                                                                                                                                                                                                 |          |
| CHECKED    | <i>[Signature]</i>                                                                                   | DRAWING NO.                                              | REV. D                                                                                                                                                                                                                                                                                                          |          |
| MFG. APPR. | <i>[Signature]</i>                                                                                   | M304TS                                                   | SHEET 1 OF 1                                                                                                                                                                                                                                                                                                    |          |
| APPROVED   | <i>[Signature]</i>                                                                                   | TITLE                                                    | SCALE                                                                                                                                                                                                                                                                                                           |          |
| DE APPR.   | <i>[Signature]</i>                                                                                   | 304/316 SQUARE TUBING                                    | NONE                                                                                                                                                                                                                                                                                                            |          |
| DATE       | 14.05.20                                                                                             |                                                          | COPYRIGHT © 2001 BY DART AEROSPACE LTD<br>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. |          |